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[54] Title of invention: A manufacturing process for a disposable color-print, aromatic table cloth and a method of producing slurry therefor.

[57] Abstract: The present invention discloses a manufacturing process for a disposable color-print, aromatic table cloth and slurry-making techniques therefor. This belongs to the category of everyday living products. The disposable tablecloth is produced through a simple and convenient process. It is highly suitable for the food and beverage and recreation industries and for household use. The volatile aromatic solvent added to the printing slurry enables products of the present invention to freshen the air and beautify the dining environment.

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## CLAIMS

1. The present invention employs electric cutters to fold and cut non-woven materials, hygienic rawstock materials, etc. according to certain specifications and then employs silk-screen printing methods to print text or images onto the cut materials.

2. The manufacturing process for a disposable color-print, aromatic table cloth and method for producing slurry as described in claim 1, characterized by the fact that the "half divide method," based on specification needs, is used to fold the non-woven material or hygienic rawstock before it is cut.

3. The manufacturing process for a disposable color-print, aromatic table cloth and method for producing slurry as described in claim 1, characterized by the fact that volatile, aromatic solvent is added to the printing slurry.

4. The manufacturing process for a disposable color-print, aromatic table cloth and method for producing slurry as described in claim 1, characterized by the fact that the emulsifying paste is an odorless bond slurry, the binding agent is 101, the color slurry is a coating color slurry, and the aromatic essence is an edible aromatic essence sold on the market or other water-based, non-toxic aromatic essence.

## DESCRIPTION

### MANUFACTURING PROCESS FOR A DISPOSABLE COLOR PRINT, AROMATIC TABLE CLOTH AND A METHOD OF PRODUCING SLURRY THEREFOR

The present invention relates to a manufacturing process for a disposable color-print, aromatic table cloth and a method of producing slurry therefor. It belongs to the category of products for everyday living.

As living standards have risen, disposable items have grown increasingly popular because they are clean and hygienic and they save time. The traditional tablecloth becomes unhygienic and unsightly with repeated use, and much time and effort are required to wash and dry it. Thus, it is gradually becoming obsolete. The present invention aims to improve dining and recreation hygiene and thereby gradually become a necessity in people's lives.

FIG. 1 is a schematic diagram of the "half-dividing method."

The following is a brief description of the technical process of the present invention in the light of the attached drawing: First, lay [illegible] width of non-woven material or hygienic rawstock material flat on a level work table. In accordance with specification L, fold it layer-by-layer until H. The folding start and end portions of the material are  $\frac{1}{2}$  L. Then, mark a straight cutting line N along the center of the top layer of the material. Using a cutter, cut along the cutting line. Because all the layers are connected to each other, when two layers are shaken apart, each half of the material is a tablecloth having specification L. Then shake apart this material layer by layer and fold. You may now print various kinds of letters or pictures thereon. The printing method used is silk-screen printing. Once completed, you have Tablecloth 1.

The printing slurry is made by blending water-based emulsifying paste, binding agent, and color slurry. Volatile aromatic solvent can be added prior to use. The proportions are: (weight proportions)

Emulsifying paste	70
Binding agent	20
Aromatic essence	4
Color slurry	3
Cross-linking agent	2
Other	1

Method of preparation: (1) Add the emulsifying paste and binding agent and color slurry to a wide-mouthed container. Mix thoroughly. (When necessary, you may use a mixing machine.) Set aside. (2) Before printing the tablecloth, add aromatic essence and mix thoroughly. (3) Add cross-linking agent, etc. depending on the situation. When this is not necessary, use additional binding agent to substitute for this proportion.

Compared to the current art, the present invention entails easy-to-obtain materials, little capital, and easy production. The method of adding fragrance to the tablecloth replaces the past production method of using a misting device. It also reduces the need for machinery investments while expanding and enriching printing slurry functions. It has

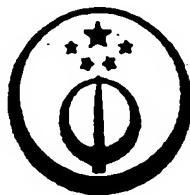
opened up an entirely new way to popularize and promote disposable everyday living products.

## DESCRIPTION DRAWINGS

[figure]

FIG. 1

D2



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权利要求书 1 页 说明书 1 页 附图页数 1 页

[54]发明名称 一次性彩印芳香台布的制作工艺及浆料制法

[57]摘要

本发明公开了一种一次性彩印芳香台布的制作工艺及浆料制法技术,属生活用品类。它通过简便易行的工艺方法,制作一次性台布,非常适用于餐饮、娱乐行业及家庭使用。印刷浆料中由于加入了挥发性香型溶剂,使本发明的产品能够清新空气、美化餐饮环境。

1. 本发明是用电动剪裁刀，将卷状无纺布、卫生原纸材料等，按一定规格折叠、剪裁，再用丝网印刷工艺方法，把文字、图案印制于已裁切好的材料上。

2. 权利要求1所述一次性彩印芳香台布的制作工艺及浆料制法的技术特征，是在裁切无纺布、卫生原纸之前，要根据规格需要用“半分法”折叠。

3. 权利要求2所述一次性彩印芳香布的制作工艺及浆料制法的技术特征，是在印刷浆料中，加入了挥发性香型溶剂。

4. 权利要求3所述一次性彩印芳香台布的制作工艺及浆料制法的技术特征，是乳化糊为无味邦浆，粘合剂用101，色浆为涂料色浆，香精要用市售食用香精或其它水性无毒香精。

## 一次性彩印芳香台布的制作工艺及浆料制法

本发明涉及一种一次性彩印芳香台布的制作工艺及浆料制法技术，属生活用品类。

随人们生活水平的提高，一次性用品以其洁净、卫生、省时而日益受到普遍青睐。传统台布因重复使用，卫生状况差、外观不佳，再加之洗涤、晾晒费工、费时，正逐步为人们所淘汰，本发明是以提高饮食娱乐卫生水平为目的，以期逐渐成为人们生活必需品之一。

图1，为“半分法”示意图。

下面结合附图，简述本发明的工艺过程：首先将W宽度的无纺布或卫生原纸材料，平置于平整的工作台上，按照规格L逐层叠厚至H，材料的折叠起始和结束部分为 $1/2L$ ，之后在材料最上一层中央部分，划一条直的剪裁线N，用剪裁机沿剪裁线剪开，每一半材料，因每层之间是相连的，两层抖开，即为一张规格为L的台布，然后将这些材料层层抖开、叠厚，即可在上面印刷各种文字、图案，印刷所采用方式为丝网印刷，完成后即为台布1。

印刷浆料是用水性的乳化糊、粘合剂及色浆等调和而成，挥发性的香型溶剂可以在使用之前加入，其配比为：（重量比）

乳化糊	70
粘合剂	20
香 精	4
色 浆	3
交联剂	2
其 它	1

制备方法为：①将乳化糊和粘合剂及色浆加入广口盛物中，搅拌均匀（必要时可用搅拌机）备用。②在印刷台布之前，将香精加入，搅拌均匀。③交联剂等要酌情加入，不需要时，可用粘合剂补足比例。

本发明与现有技术相比，取材容易、投资小、制作简便。在为台布赋香方法上，改变了以往用喷雾装置施工的工艺方法，也节省了器械投资，扩大、丰富了印刷浆料的功能，为一次性生活用品的进一步普及推广开拓了一条全新道路。



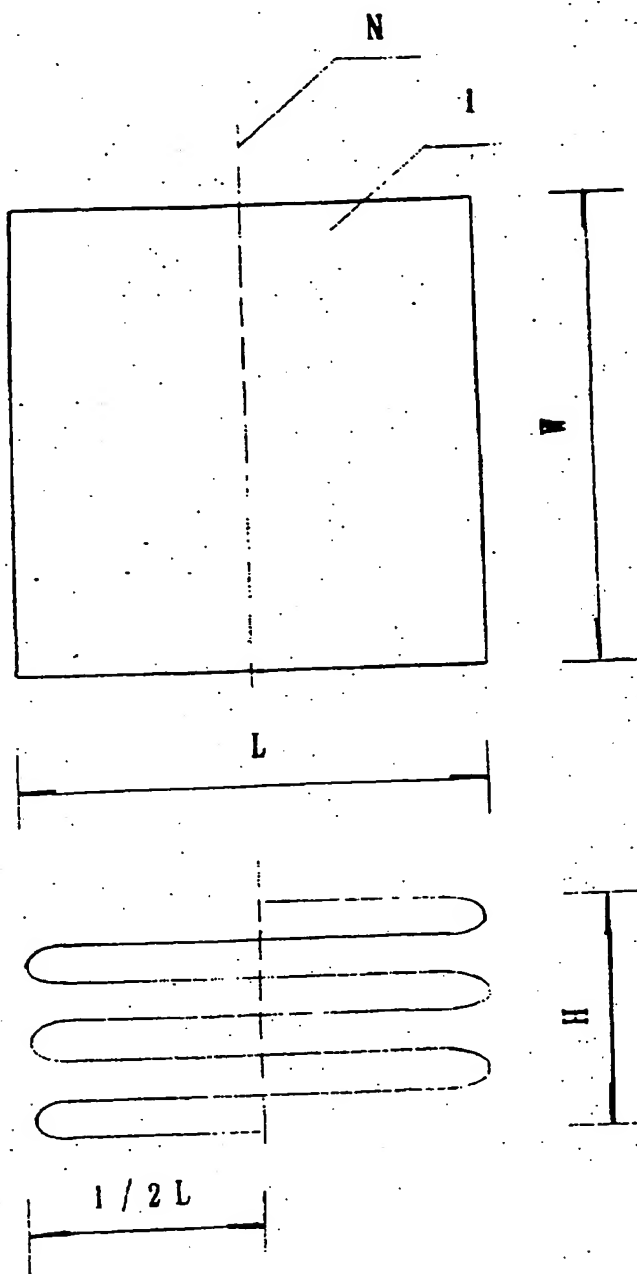


图 1